

Date: Monday, 04/02/2008 3:16:05 PM
 User: Dominique Dube

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	206L FLOAT STEP
Job Number :	36493		
Estimate Number :	10850		
P.O. Number :		Part Number :	D206628024
This Issue :	04/02/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	N/A
First Issue :	20/12/2007	Project Number :	N/A
Previous Run :	34576	Drawing Revision :	N/A
	Type :	Material :	
	LARGE FAB ASSY	Due Date :	20/01/2008
Written By :		Qty:	6 Um: Each
Checked & Approved By :			
Comment :	Est Rev:D As Per Ecn 766 06-01-06 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy blue file and type labels as per PPP D206-628-024 CHG 002 003 per Ecn 1118

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

UPDATED AS PER ECN 1118, D206-268-024 CHG NUM. 003

3.0	36493A	FLOAT STEP ASSEMBLY RH (206/407)
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Comment: Sub-Component FLOAT STEP ASSEMBLY LH (206/407)

D2842-042 B 36493 A

4.0	D27317	Mounting Lug
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 24.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	D2731-7	Mounting Lug	1334125

5.0	D28441	Arm
-----	--------	-----



Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	D2844-1	Arm	13341600

8/2/5 SQ (6x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 04/02/2008 3:16:05 PM
User: Dominique Dube

Process Sheet

DSI 9332

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FLOAT STEP

Job Number: 36493

Part Number: D206628024

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D28443

Arm



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D2844-3

Arm

13341001 (3x)

1334826 (3x) SP

7.0

D2732030

Rubber Cushion



Comment: Qty.: 8.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick:

Qty Part #

Description

Batch

8 D2732-030

RUBBER CUSHION

1334717

SP

8.0

D3394043

LUG ASSY



Comment: Qty.: 4.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 D3394-043

LUG ASSY

1334917 (16x)

1334834 (8x)

SP

9.0

AN3C4A

BOLT



Comment: Qty.: 3.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3 AN3C4A

Bolt

M105559

SP

10.0

AN4C14A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN4C14A

Bolt

M107087

M107087 min 2008/2/13

8/2/11 SP

11.0

AN4C15A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN4C15A

Bolt

M106785

8/2/5 SP (6x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 12/20/2007 3:22:53 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FLOAT STEP

Job Number: 36493

Part Number: D206628024

Job Number:



Seq. #:

Machine Or Operation:

Description:

12.0

AN4C15A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 24.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN4C15A

Bolt

M1004472 (4x)

M103915 4x

M100329 2x

M106785 (16x)

SQ

13.0

AN960C10

WASHER



Comment: Qty.: 3.0000 EACH(s)/Unit Total: 18.0000 EACH(s)

Pick:

Qty Part Number

Description

Batch

3 AN960C10

WASHER

M106302

SQ

14.0

AN960JD416L

Washer



Comment: Qty.: 24.0000 Each(s)/Unit Total: 144.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

24 AN960JD416L Washer

M106303 (144x)

M106916 (32x)

SQ

15.0

NAS1515H4L

WASHER



Comment: Qty.: 24.0000 Each(s)/Unit Total: 144.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

24 NAS1515H4L Washer

M105792

SQ

16.0

MS210434

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total: 72.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

12 MS21043-4 Nut (or MS21042-4)

M105793 (12x)

M106421 (4x)

M106763 (11x)

SQ

17.0

NAS1515H3

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total: 18.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3 NAS1515H3 Washer

M106431

8/2/5 SQ

(6x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 08/02/14

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 12/20/2007 3:22:53 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FLOAT STEP

Job Number: 36493

Part Number: D206628024

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

CS 08/21/13 (46)

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-628-024

Location: _____

PPP Rev: _____

G

CS 08/21/13 (4)

20.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(6)
D 08/22/14

Job Completion



min 2008/2/13 (6)
u

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

628-024

Dart Aerospace Ltd.

4

Date: Thursday, 12/20/2007 3:23:03 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FLOAT STEP ASSEMBLY RH (206/407)
 Job Number : 36493A
 Estimate Number : 11775
 P.O. Number :
 This Issue : 12/20/2007 S.O. No. :
 Prsht Rev. : NC Part Number : D2842042
 First Issue : 1 / 1 Type : LARGE FAB ASSY Drawing Number : D2842 REV B
 Previous Run : 34576A Drawing Revision : B
 Written By :
 Checked & Approved By : 12/21
 Comment : Est Rev:D As Per Ecn 766 06-01-06 JLM
 Material :
 Due Date : 1/20/2008 Qty: 6 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 D2622120C Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Qty	Part #	Description	Batch:
1	D2622-120C	Extrusion	<u>335618</u>

Check Material for any Dents or Defects

12/08.01.21 6

2.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2842-1 using D2622 extrusion as per Dwg D2842

2-Drill D2842-1 using Jig DT8272 as per Dwg D2842

3-Deburr and bevel ends for welding

12/08.01.21 6
12/08.01.21 6
12/08.01.21 6

3.0 D2734 206 Step Endplate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

206 Step Endplate

Pick:

Qty	Part Number	Description	Batch
2	D2734	End Cap	<u>334485</u>

12/08.01.21 6

4.0 D34591 plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

plate

Batch: 334429

12/08.01.21 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 12/20/2007 3:23:03 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT STEP ASSEMBLY RH (206/407)

Job Number: 36493A

Part Number: D2842042

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

D34593

plate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s)

plate

Batch:

334430

SE 08.01.21 6

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld one end cap and (2) lugs as per Dwg D2842

A/R AL Rod Batch:

M105844
M105058

SE 08.01.21 6

2-Grind end cap weld flush

SAD 08.01.24 6

~~SE 08.01.21 6~~

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08.01.24 6

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08.01.25 6 (24)

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD 08.01.27 6

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SE 08.01.29 6

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Remove alodine prior to welding.

Weld end cap as per Dwg D2842.

SE 08.01.29 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 12/20/2007 3:23:03 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT STEP ASSEMBLY RH (206/407)

Job Number: 36493A

Part Number: D2842042

Job Number:



Seq. #:

Machine Or Operation:

Description:

A/R AL Rod Batch: M105058 *FL*

2-Grind end cap weld flush.

3AD 08-01-29 (6)

12.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-01-29 (6)

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/01/09 4624

14.0

POWDER COATING

POWDER COATING



M106379

M-h



08/02/04 (6X RH)

Comment: POWDER COATING

Touch up Alodine end cap and Powder Coat Gloss White (Ref: 4.3.5.1) as per CSI 005 4.3

08/02/01 (ALD. b. n. d.)

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 08/02/04 (6)

16.0

NAS1329C3KB130

insert



Comment: Qty.: 3.0000 Each(s)/Unit Total: 18.0000 Each(s)

Insert

Pick:

Qty Part Number

Description

Batch

3

NAS1329C3KB130

Insert

M105385

FL

17.0

MS27039C107

screw



Comment: Qty.: 3.0000 Each(s)/Unit Total: 18.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3

MS27039C1-07

Screw

M105426

FL

18.0

NAS1515H3L

WASHER



Comment: Qty.: 3.0000 Each(s)/Unit Total: 18.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3

NAS1515H3L

WASHER

M106516

FL 08/02/04 (6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 12 Date: 08/02/14
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 12/20/2007 3:23:03 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT STEP ASSEMBLY RH (206/407)

Job Number: 36493A

Part Number: D2842042

Job Number:



Seq. #:

Machine Or Operation:

Description:

19.0

AN960C10L

washer



Comment: Qty.: 3.0000 Each(s)/Unit Total: 18.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3

AN960C10L

WASHER

M106883

FZ

20.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: FINISHING 1

1-Install inserts as per Dwg D2842

2-Wing Walk as per Dwg D2842 and QSI 005 4.1

Batch: M106894

FZ 08/02/04 (6)

FZ 08/02/05 (6)

21.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/02/05 (x6042)

22.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PP 36493

8/2/04 34

(6x)

23.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

12/08/02/17 (6)

Job Completion



pin 2008/2/13

(6)

U

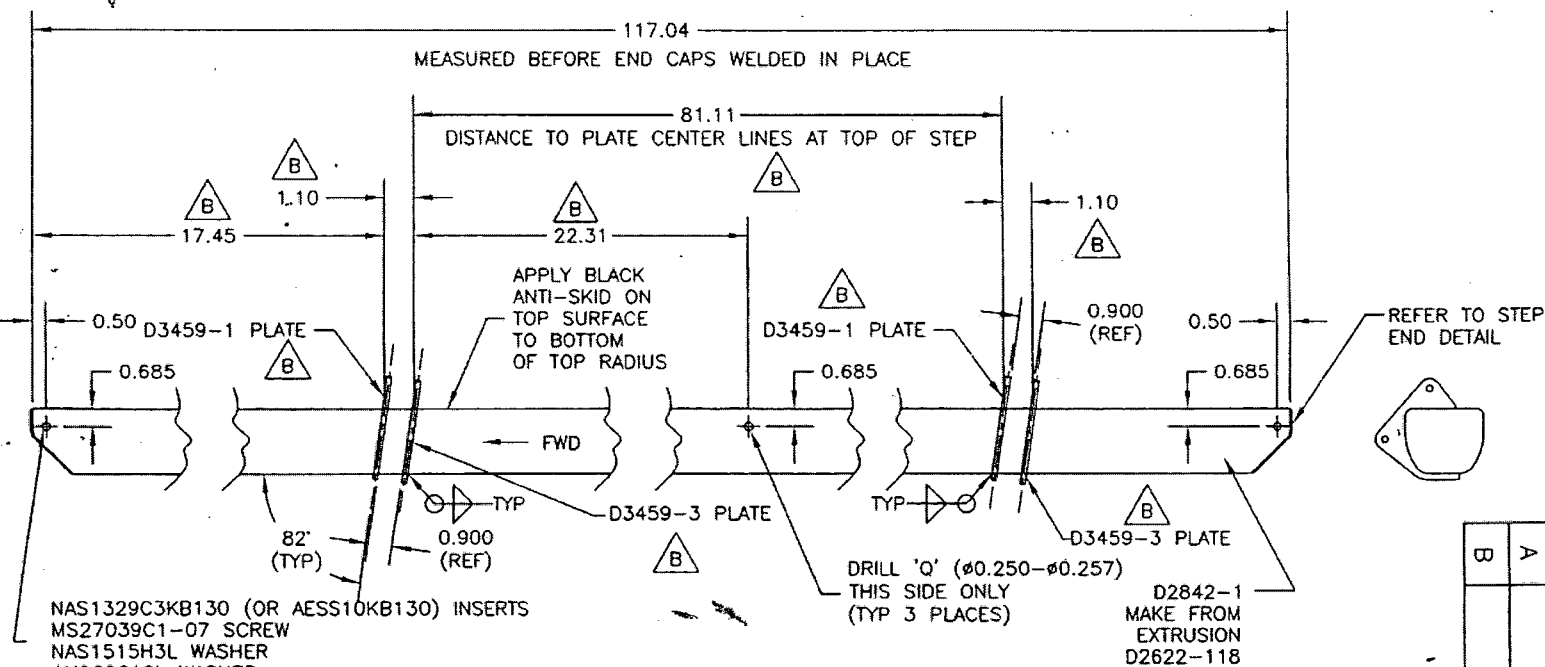
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

NAS1329C3KB130 (OR AESS10KB130) INSERTS
MS27039C1-07 SCREW
NAS1515H3L WASHER
AN960C10L WASHER
(TYP 3 PLACES)

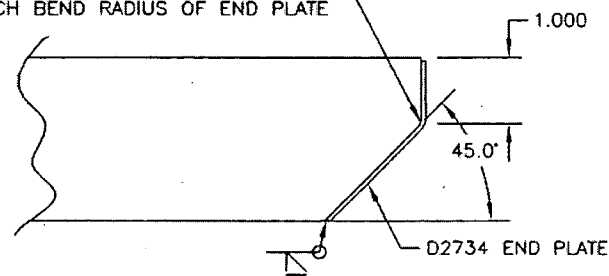
D2842-041 LH STEP ASSEMBLY (SHOWN)
D2842-042 RH STEP ASSEMBLY (OPPOSITE)

NOTE: ALL WELDS SHALL
BE 100% VISUALLY
INSPECTED BY A QUALIFIED
INSPECTOR PER DART
QSI 004

D2842-041/-042 FLOAT STEP ASSEMBLY PARTS LIST

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X	X	D2842-041	LH STEP ASSEMBLY
		D2842-042	RH STEP ASSEMBLY
1	1	D2622-118	EXTRUSION
2	2	D2734	END PLATE
2	2	D3459-1	PLATE
2	2	D3459-3	PLATE
3	3	NAS1329C3KB130 (OR AESS10KB130)	INSERT
3	3	MS27039C1-07	SCREW
3	3	NAS1515H3L	WASHER
3	3	AN960C10L	WASHER

ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE



TYPICAL STEP END DETAIL
NOT TO SCALE

D2842-041/-042 FLOAT STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED

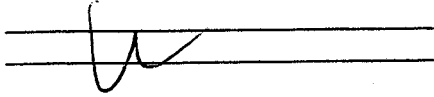
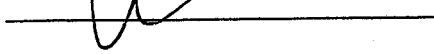
05-11-14

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
NO WORK ORDER
#049374

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
KE	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D2842
DATE 05.09.23	05.09.23	206L/407 FLOAT STEP ASSEMBLY
A	98.10.13	NEW ISSUE
B	05.09.23	RE-DESIGN, ADD D3459-1/-3
		SHEET 1 OF 1
		SCALE NTS

Date: Friday, 18/04/2008 7:50:09 AM
 User: Linda Lacelle

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D206-628-UPDATE PAPERWORK
Job Number	: 38685		
Estimate Number	: 10804		
P.O. Number	:	Part Number	: Z_CUSTOM
This Issue	: 18/04/2008 S.O. No. :	Drawing Number	: ECN1126
Prsht Rev.	: NC	Project Number	:
First Issue	: / / Type : LARGE FAB ASSY	Drawing Revision	:
Previous Run	: 00015	Material	:
Written By	: 	Due Date	: 25/04/2008 Qty: 1 Um: Each
Checked & Approved By	: 		
Comment	:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

PULL FROM STOCK:

D206-628-011	33038	(3x)	33411	(3x)
D206-628-012	33892	(1x)	33412	(1x)
D206-628-013	36963	(4x)	36078	(1x)
D206-628-014	36961	(6x)		
D206-628-021	31974	(1x)	34980	(1x)
D206-628-022	33757	(1x)	34981	(3x)
D206-628-023	36492	(1x)	34575	(2x)
D206-628-024	36493	(1x)	34576	(3x)
D206-628-031	31010	(4x)		
D206-628-032	31011	(4x)		
D206-628-033				
D206-628-034				

(56x)

ADD NEW PAPERWORK TO KITS IN STOCK
 DSI 9332, PER ECN 1126

8/14/24 500